

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028358**Date Inspected:** 05-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR**CWI Name:** Jim Vanek**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Split Collars**Summary of Items Observed:**

This Quality Assurance Inspector (QAI), Dan Chang, witnessed Quality Control Inspector (QCI), Jim Vanek, of American Bridge Manufacturing (ABM) monitored the repair welding of split collars of CCO 223. QCI was witnessed to monitor welding amperage, 155, and voltage, 13.7, with an Amprobe Model ACDC-100. Repair welding was performed by Gas Tungsten Arc Welding (GTAW) using ER70S-2 3/32" diameter electrode in accordance to Welding Procedure Specification (WPS) # ABM-GTAW-01. This QAI witnessed Ben Price to grind off rust within the void to bright metal and preheat to at least 250°F prior to welding using Extech mini-infrared thermometer Model 42500. This QAI verified amperage and voltage with Fluke ammeter Model 337. Repair welding on split collars were observed at regular intervals by this QAI.

Split collars from Group 5 that were completed repairing during this work shift are BIF-066-11, BIF-134-23, BIF-077-13, and BIF-523-88.

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Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	BIF-066-11	ABM-GTAW-01	Jim Vanek	155	13.7	3 ipm	250	Void was welded and surface ground smooth
2	BIF-523-88	ABM-GTAW-01	Jim Vanek	155	13.7	3 ipm	250	Void was welded and surface ground smooth
3	BIF-077-13	ABM-GTAW-01	Jim Vanek	155	13.7	3 ipm	250	Void was welded and surface ground smooth
4	BIF-134-23	ABM-GTAW-01	Jim Vanek	155	13.7	3 ipm	250	Void was welded and surface ground smooth

Summary of Conversations:

No significant conversations occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas, (916) 764-6027, who represents the Office of Structural Materials

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for your project.

Inspected By:	Chang,Dan	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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